

Work Order ID 56634



Page 1

March 3, 2010 8:55:22 AM

Item ID:- D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10 Start Qty: 11.00



Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 11.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

5/10/01

KL for CL 10/04/01

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M110130
M111311

3-Grind End Plate flush

10.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56634

March 3, 2010 8:55:27 AM

Page 2

Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10 Start Qty: 11.00

Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 11.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(+11) BE 10-03-23

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. 03/23

(+11/R)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-03-23

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56634

March 3, 2010 8:55:27 AM



Page 3

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10 Start Qty: 11.00



Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 11.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

PK 10-3-23

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R (Aluminum Rod) 211134

10-03-29

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56634

Page 4

March 3, 2010 8:55:32 AM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10 Start Qty: 11.00



Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 11.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(11) RD 10.03.30

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/03/30



210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> 10/03/31



9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56634

Page 5

March 3, 2010 8:55:32 AM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10 Start Qty: 11.00



Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 11.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M113170

0.00

=> M

10/03/31

11 RH

✓

Memo

0.00

START TIME: 8:30 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00 AM

230



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

M113162

0.00

BR

10-3-31

11 RH

✓

Memo

0.00

240



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

10-3-31 SP 110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56634

March 3, 2010 8:55:38 AM



Page 6

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10 Start Qty: 11.00



Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 11.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

103-31 SP (140)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 10/04/01

711
RH

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: _____

Rev B

104-1 SP (140)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56634

March 3, 2010 8:55:38 AM



Page 7

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10 Start Qty: 11.00



Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 11.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/05 *[Signature]*

u 10/04/05

Picklist Print

March 3, 2010 8:55:05 AM

Page 1

Work Order ID: 56634

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Comments: IPP Rev:A 04.03.22 New issue [KJ/RF]

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:c

Start Date: 3/15/10

Required Date: 3/26/10

Start Qty: 11.00

Required Qty: 11.00

D3065-041 Manufactured No

Each 47.0000 11.0000



Step Leg Assembly Hi

10.03.24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

47

53795

17

55450

30

D3066-1 Manufactured No

Each 16.0000 22.0000



Spacer

11

10.03.24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

356752

16

51545

11

53783

5

D3219-1 Manufactured No

Each 32.0000 22.0000



Plate

22

10.03.18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

356826

32

53789

32

15

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 3, 2010 8:55:05 AM

Work Order ID: 56634

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10

Required Date: 3/26/10

Comments: IPP Rev:A 104.03.22 New issue KJ/RF

Start Qty: 11.00

Required Qty: 11.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

D3067-1 Manufactured No 110 Each 27.0000 11.0000



End Plate

10.03.18

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST *B57011* 27
53784 27

10
1

D3272-1 Manufactured No 110 Each 0.0000 11.0000



Step

MS21042L5

82

Purchased No 110 Each 391.0000 22.0000



Nut

10.03.18 (B56635) 11

10-3-31

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 390
110382 10
111636 1
112314 16
113523 163
113537 200

17
5

Main Warehouse

ST139 1
112314 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 3, 2010 8:55:05 AM

Work Order ID: 56634



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10

Required Date: 3/26/10

Comments: IPP Rev:A 04.03.22 New issue [KJ/RF]

Start Qty: 11.00

Required Qty: 11.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

MS20600-AD4W4

Purchased

No

180

Each

995.0000

176.0000



Rivets

10-03-24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

995

110731

215

111359

46

111477

74

112314

136

112385

24

113368

500

176.

AN3-35A

Purchased

No

260

Each

195.0000

22.0000



Bolt

103-31-24 (112)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

195

106993

12

110467

1

112314

182

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 3, 2010 8:55:06 AM

Work Order ID: 56634

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10

Required Date: 3/26/10

Comments: IPP Rev:A[104.03.22]New issue [1]KJ/RF[1]

Start Qty: 11.00

Required Qty: 11.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

AN4-13A Purchased No 260 Each 211.0000 88.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 211

113359 11

113749 200

17406 0

51764 0

AN5-36A Purchased No 260 Each 115.0000 22.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 115

109545 11

110467 7

110731 4

112243 20

112314 23

112385 50

AN960JD10 Purchased No 260 Each 0.0000 44.0000



Washer

March 3, 2010 8:55:06 AM

Shop Packet Print

44x
M114227
M114181
10-3-31 SP

10-3-31 SP
M112492 5X
104-150

M113282 10-3-31 110 SP
M112492
10-3-31 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 3, 2010 8:55:07 AM

Work Order ID: 56634

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10

Required Date: 3/26/10

Comments: IPP Rev:A 04.03.22 New issue [KJ/RF]

Start Qty: 11.00

Required Qty: 11.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:c

AN960JD416 *sl* Purchased No *NA51149D04632* 260 Each 0.0000 176.0000



Washer

AN960JD516 *sl* Purchased No *NA51149D05632* 260 Each 0.0000 44.0000



Washer

D2230-3 *sl* Manufactured No 260 Each 178.0000 44.0000



Lug

M113706 16-3-31 sl
(3) *sl 10-3-31*
M113524 M113706 412
10-3-31 sl (1K)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

50306

5

51568

2

Main Warehouse

ST176

150

55310

150

Main Warehouse

ST476

21

55310

21

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

March 3, 2010 8:55:07 AM

Work Order ID: 56634

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10

Required Date: 3/26/10

Comments: IPP Rev:A 04.03.22 New issue [KJ/RF]

Start Qty: 11.00

Required Qty: 11.00

IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

D2618 82

Manufactured No

260

Each

61.0000

22.0000

9x

1356892

10-3-31



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST39

61

50989

61

4x Autoclave to Sunk

11x

D2856-400

42 @ 7.20" → mess

Manufactured No

260

f

249.0321

6.6000

10-3-31



Abraison Strip

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

249.0320842

50593

138.592084

52563

110.44

✓

D3067-1

Manufactured No

260

Each

27.0000

11.0000

10-03-24



End Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

357011

27

53784

27

11

March 3, 2010 8:55:07 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 3, 2010 8:55:08 AM

Work Order ID: 56634



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10

Required Date: 3/26/10

Comments: IPP Rev:A [04.03.22] New issue [KJ/RF]

Start Qty: 11.00

Required Qty: 11.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

D3235-1 *x2* Manufactured No 260 Each 107.0000 22.0000



Mounting Lug



10-3-31

sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

471 60

55315 60

22

Main Warehouse

ST 47

45398 4

54756 43

D3278-041 *cl* Manufactured No 260 Each 63.0000 11.0000



Support Assembly



10-3-31

sf

(11)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 23

53227 23

Main Warehouse

ST471 40

55318 40

11x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

March 3, 2010 8:55:08 AM

Work Order ID: 56634



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10

Required Date: 3/26/10

Comments: IPP Rev:A 04.03.22 New issue [KJ/RF]

Start Qty: 11.00

Required Qty: 11.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

MS21042L3 K2

Purchased

No

260

Each

2,470.000

22.0000



Nut



10-3-31

SV (12)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2464

110844

35

111274

27

111668

52

112314

285

112385

347

113523

18

113537

700

113644

1000

22

Main Warehouse

ST139

6

111668

6

March 3, 2010 8:55:08 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

March 3, 2010 8:55:21 AM

Work Order ID: 56634



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/15/10

Required Date: 3/26/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 11.00

Required Qty: 11.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

MS21042L4

XB

Purchased

No

260

Each

1,821.000 88.0000



Nut



10-3-31

SL

1K

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1821

102552

6

104248

6

110507

184

111827

631

113422

994

15924

0

88

March 3, 2010 8:55:21 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

GENERAL NOTES:

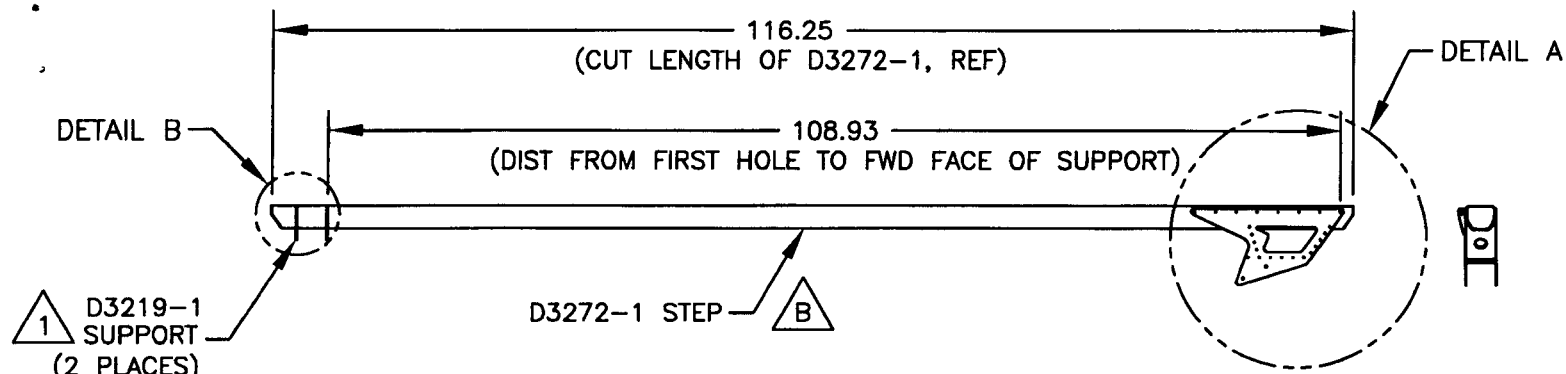
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*07/06/04***Copyright © 2004 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

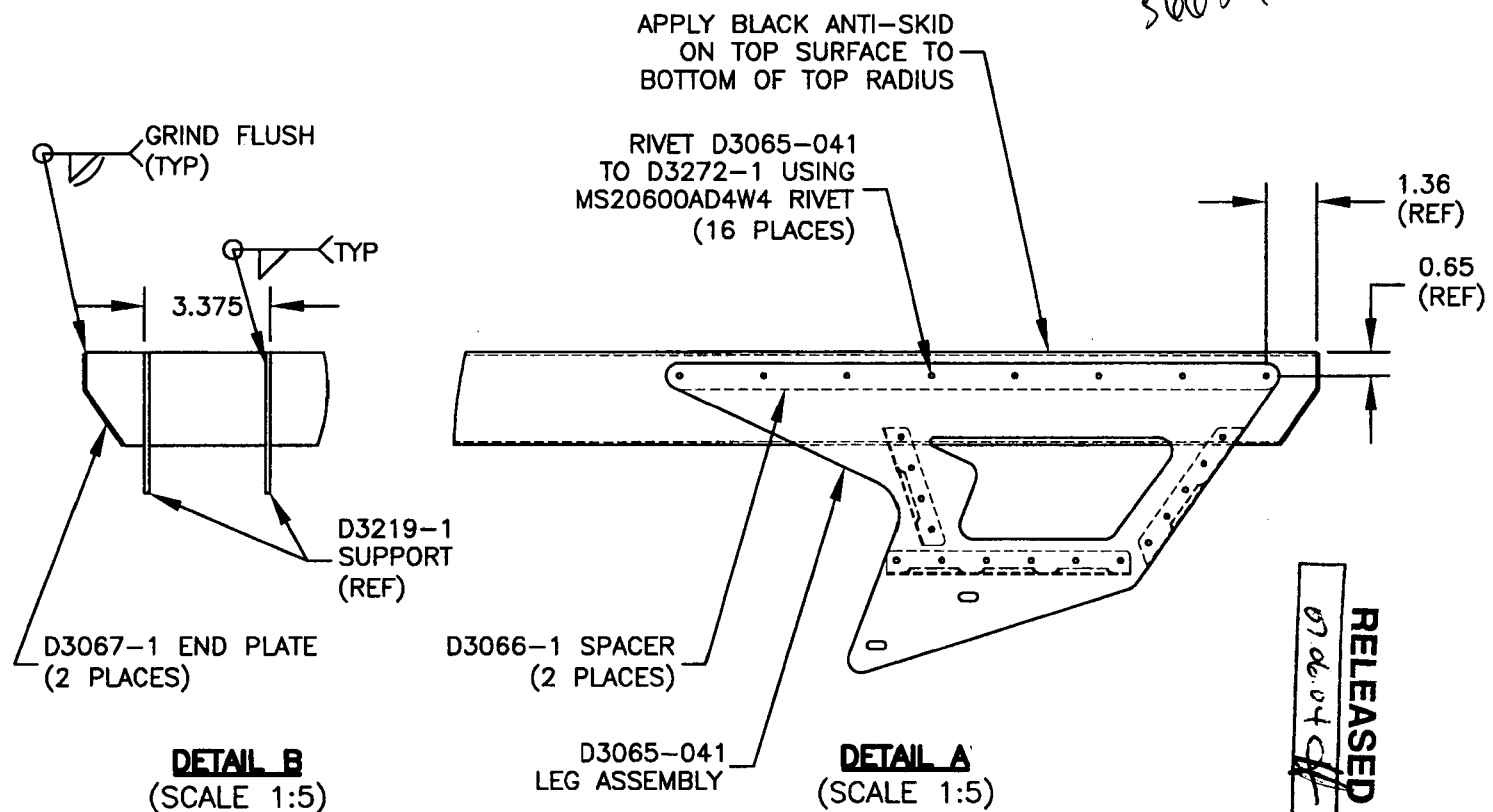


DESIGN	40	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JE	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
				SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

WLO 56634

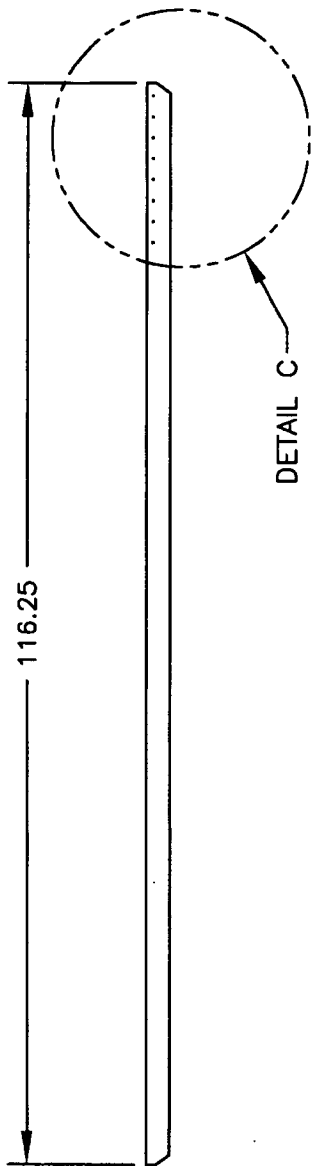


THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2004 by DART AEROSPACE LTD



DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

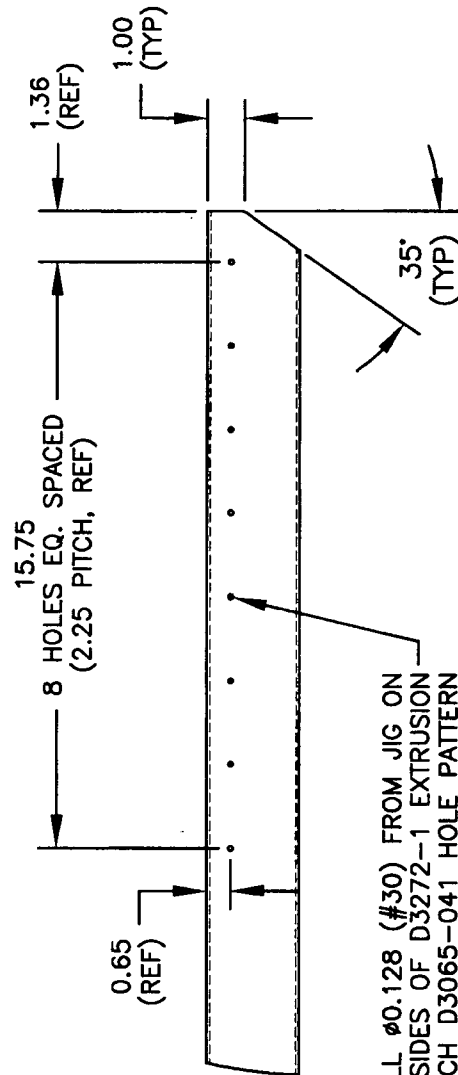


DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)

Handwritten: 46634



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10		6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-31-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

• COPYRIGHT © 1993 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **G**
Date: 08.10.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries